

Work Order ID 133659

Tuesday, June 16, 2015 9:16:32 AM

133659

Page 1

Item ID: PB67-43001-07

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Blade Fold Assembly Weldment

Stop ***NS2***

Start Date: 6/16/2015 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: JUN 16 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-07	D

100 Weld per dwg A/R Aluminum rod Batch: 131562 0.00
Large Fab

100

Large Fab

Large Fab

Memo 0.00

1- Assemble parts on jig DT8813 and weld as per dwg PB67-43001

*** Ensure no burn thru after welding in tube -205 and -197 only where
bushing -265 ***

3 AUG 11 2015 DAS
24
9-89

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo 0.00

(3) 15-08-11 PD

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

③ 15-08-11 PD

130

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

***MASK ALL OPENING AND INDICATED AREAS PRIOR TO
POWDERCOATING, SEE NOTE 9 SHEET 2-3****

START TIME:

1:45

OVEN TEMPERATURE:

320°

FINISH TIME:

2:15

3 15-8-17 333

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							
140									DAS
QC	Memo	0.00				3			38
Quality Control									9-89
									AUG 18 2015
150	Identify as per dwg & Stock Location: <u>WA4</u>	0.00							
150									DAS
Packaging	Memo	0.00				3			24
Packaging									9-89
									AUG 24 2015
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									
									MLJ
									AUG 24 2015

SH 20150824

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Picklist Print

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Page 1

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133659

Parent Item: PB67-43001-07

PR67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec IPP rev B
10.09.24 per revC dwg EC verified by:DD IPP REV:C 14.12.15
DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-205W		Manufactured	No				Each	0.0000		3			
PR67-43001-205W									**				
Outer Tube Weldment													
PB67-43001-197W		Manufactured	No			100	Each	0.0000	1	3			
PR67-43001-197W									**				
Outer Tube Weldment													
PB67-43001-203W		Manufactured	No			100	Each	0.0000	1	3			
PR67-43001-203W									**				
Square Tube Weldment													
PB67-43001-207W		Manufactured	No			100	Each	0.0000	1	3			
PR67-43001-207W									**				
Square Tube Weldment													
PB67-43001-47		Manufactured	No			100	Each	0.0000	1	3			
PR67-43001-47									**				
Base Assembly													
PB67-43001-201		Manufactured	No			100	Each	2.0000	1	3			
PR67-43001-201									**				
Square Tube													

Location

WA003

133240

Loc Qty

2

2

Loc Code

133662 - MF 15-7-17

**B133694 -> 3 AUG 06 2015
DAS 24 9-89

133663 - MF 15-8-5

133664 - MF 15-8-5

99984 x 3 - MF 15-2-17

B133644 - MF

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Page 2

Work Order ID: 133659

133659

Parent Item: PB67-43001-07

PB67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-209

Manufactured No

100

Each

1.0000

1

3

PR67-43001-209

Square Tube

Location

Loc Qty

Loc Code

Mezz2

1

112748

1

100

Each

6.0000

6

18

2x133666
MF 15-7-15

PB67-43001-211

Manufactured No

PR67-43001-211

Square Tube

Location

Loc Qty

Loc Code

WA003

6

133241

6

100

Each

2.0000

1

3

133667 x 18
MF 15-8-14

PB67-43001-219

Manufactured No

PR67-43001-219

Angled Male Eye

Location

Loc Qty

Loc Code

Mezz2

2

110598

2

100

Each

4.0000

1

3

133668 x 1
MF 15-7-17

D3440-7

Manufactured No

D3440-7

Detent Clip Base (Supersedes B67-43001-221)

Location

Loc Qty

Loc Code

Mezz2

4

111739

4

100

Each

4.0000

1

3

MF 15-7-17

D3440-5

Manufactured No

D3440-5

Contoured Detent Clip Base (Supersedes B67-43001-217)

Location

Loc Qty

Loc Code

Mezz2

4

111738

4

MF 15-7-17

Tuesday, June 16, 2015 9:16:35 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 3.00

Required Qty: 3.00

D3440-15

Manufactured No

100

Each

4.0000

1

3

D3440-15

Contoured Male Eye (Supersedes B67-43001-215)

Location

Loc Qty

Loc Code

Mezz2

4

4

111737

MF 5-9-17

DQA: _____ Date: _____

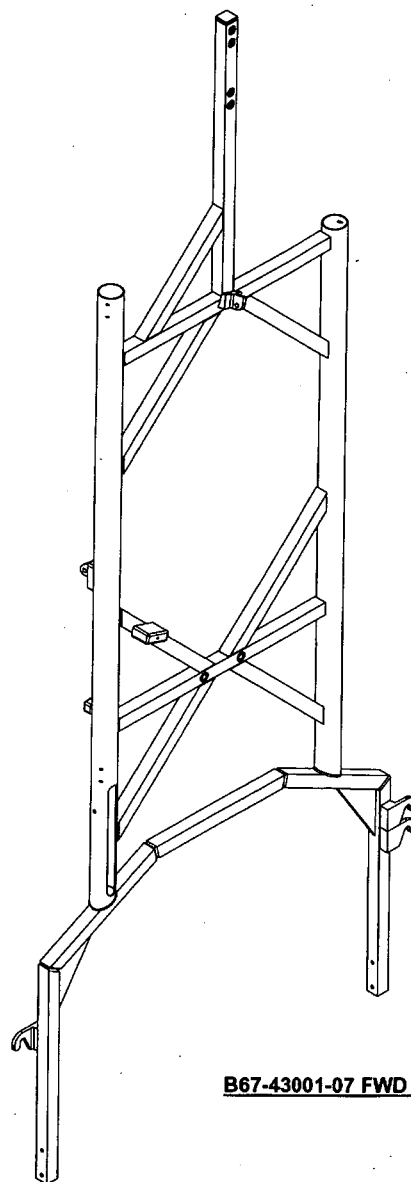


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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					



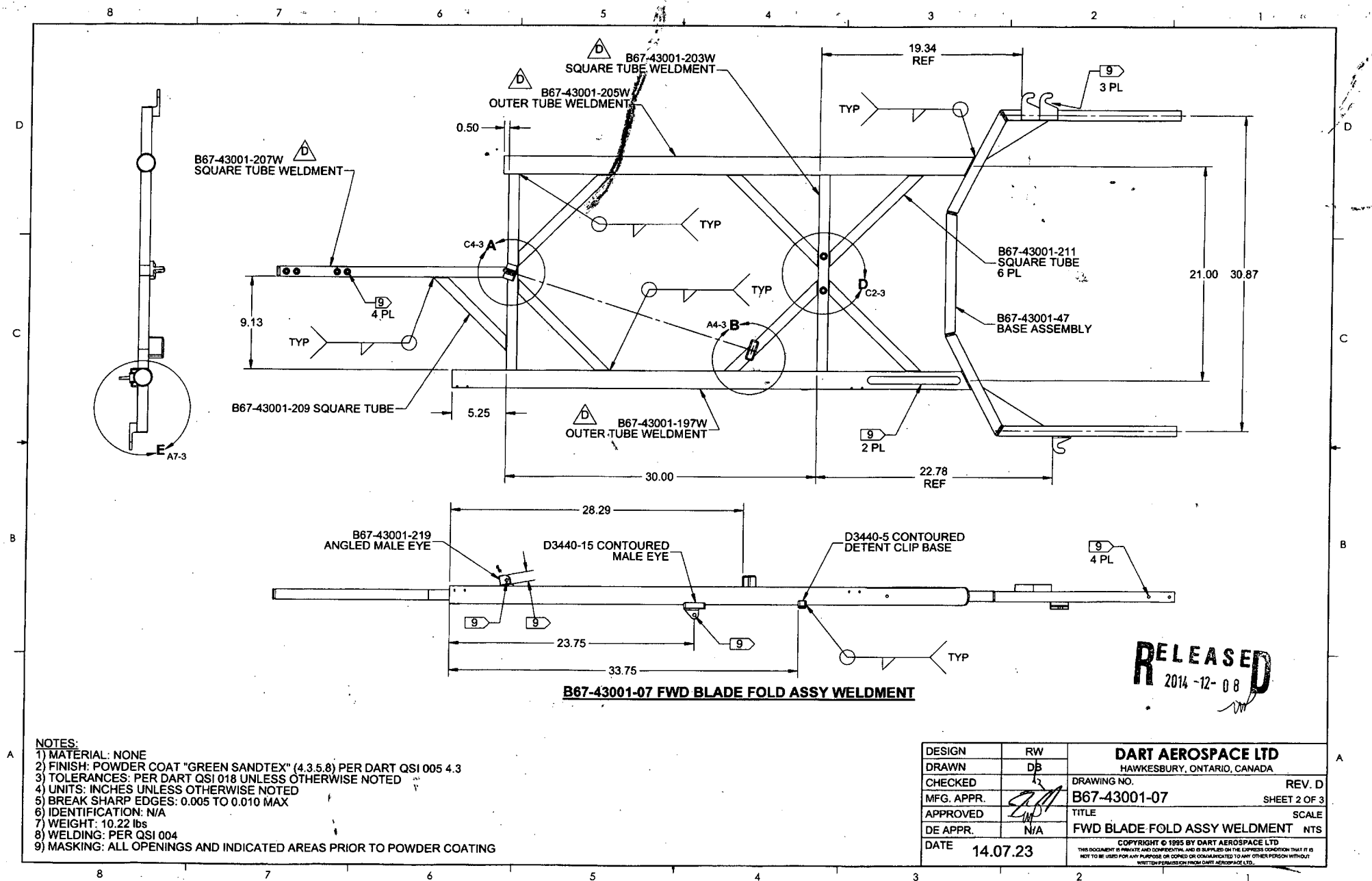
B67-43001-07 FWD BLADE FOLD ASSY WELDMENT

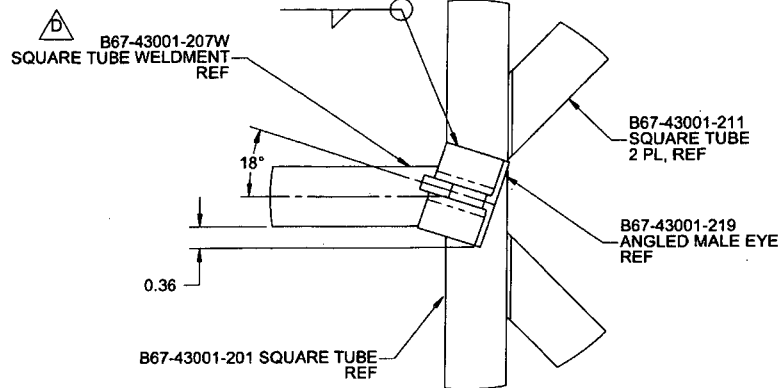
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WORK ORDER
NO 133659 MLJ
1506-16

ITEM	QTY -07	P/N	DESCRIPTION
1	X	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-47	BASE ASSEMBLY
3	1	B67-43001-197W	OUTER TUBE WELDMENT
4	1	B67-43001-201	SQUARE TUBE
5	1	B67-43001-203W	SQUARE TUBE WELDMENT
6	1	B67-43001-205W	OUTER TUBE WELDMENT
12	1	B67-43001-207W	SQUARE TUBE WELDMENT
8	1	B67-43001-209	SQUARE TUBE
9	6	B67-43001-211	SQUARE TUBE
10	1	B67-43001-219	ANGLED MALE EYE
11	1	D3440-5	CONTOURED DETENT CLIP BASE
12	1	D3440-7	DETENT CLIP BASE
13	1	D3440-15	CONTOURED MALE EYE

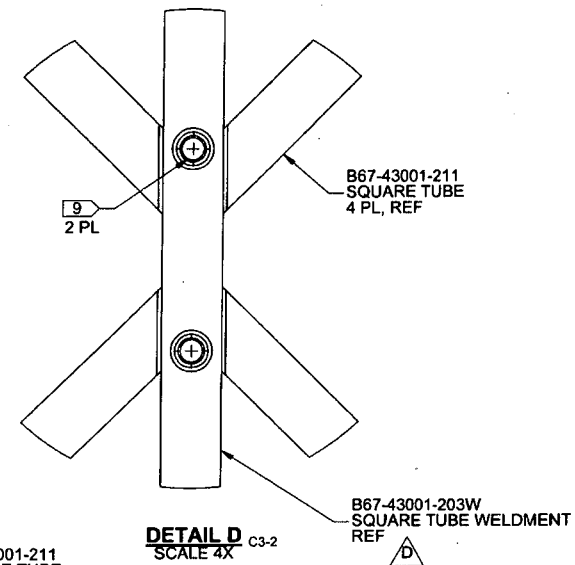
RELEASED
2014-12-08
WJD

D	REVISE BOM AND ANNOTATIONS TO INCLUDE -197W/-203W/-205W & -207W WELDMENTS, DELETE DETAIL C REASON: TO FACILITATE MANUFACTURING	DB	14.07.23
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 5 OF PREMIER AVIATION DRAWING # B67-43001. REASON: SEE PAR #09-011	MB	10.05.04
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	B67-43001-07	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	FWD BLADE FOLD ASSY WELDMENT	NTS
DATE	14.07.23	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

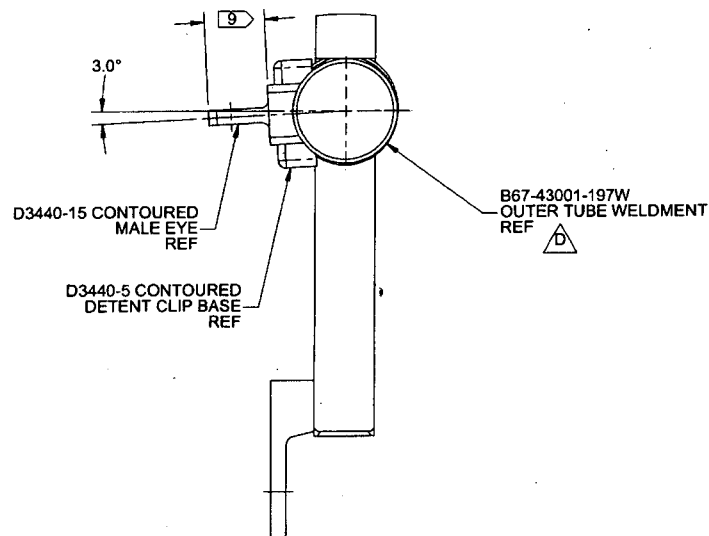




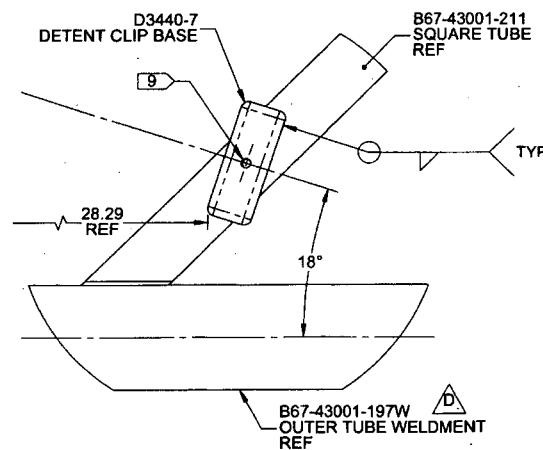
DETAIL A
SCALE 4X C6-2



DETAIL D
SCALE 4X C3-2



DETAIL E
SCALE 4X B8-2



DETAIL B
SCALE 4X C4-2

RELEASED
2014-12-08

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	TR	DRAWING NO.	REV. D
MFG. APPR.	TR	B67-43001-07	SHEET 3 OF 3
APPROVED	TR	TITLE	SCALE
DE APPR.	N/A	FWD BLADE FOLD ASSY WELDMENT	NTS
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